

Date: Thursday, 2/9/2006 1:17:21 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TUBE ASSEMBLY
Job Number : 25793	
Estimate Number : 11527	
P.O. Number : N/A	Part Number : D3021041
This Issue : 2/9/2006 S.O. No. : N/A	Drawing Number : D3021 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LARGE FAB ASSY	Drawing Revision : A
Previous Run : N/A	Material : N/A
Written By : <u>See comment below</u>	Due Date : 2/25/2006 Qty: 1 Um: Each
Checked & Approved By : <u>06.02.09</u>	
Comment : Est. 01.10.23 New Issue SM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M4130NT0750W049	4130 Tube .750 OD x.049W



Comment: Qty.: 2.1875 f(s)/Unit Total : 2.1875 f(s)
 4130 Tube .750 OD x.049W
 Cut:- AISI 4130N tube, Ø3/4" x 0.049" wall batch: M10133

06/02/10

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1
 1-Cut tube as per Dwg D3021

 2-Drill tube as per Dwg D3021 using D3021-041T1

 3--Deburr

06/02/10

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

PD 06-02-13

4.0	M4130NS049	4130 Sheet .049 wall
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Comment: Qty.: 1.0500 sf(s)/Unit Total : 1.0500 sf(s)
 4130 Sheet .049 wall
 Cut:- AISI 4130N sheet, 18 gauge (0.050 thick)
 batch: ~~M10133~~ M16443
 Identify For D3017-11 Cap

06/02/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DP Date: 06/02/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE ASSEMBLY

Job Number: 25793

Part Number: D3021041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut end caps as per Dwg D3017

2-Weld as per Dwg D3021

A/R Steel Rod Batch: M9430

AA 06/02/13

6.0

QC5/9

WELD INSPECTION



Comment: VISUAL WELDING INSPECTION

Inspect Level 9

Inspect for foreign objects per QSI 024

PD 06-02-13

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

FC 06 02 21

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 06/02/21

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 06/02/21

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

545 06/02/22

(1) 06/02/22

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

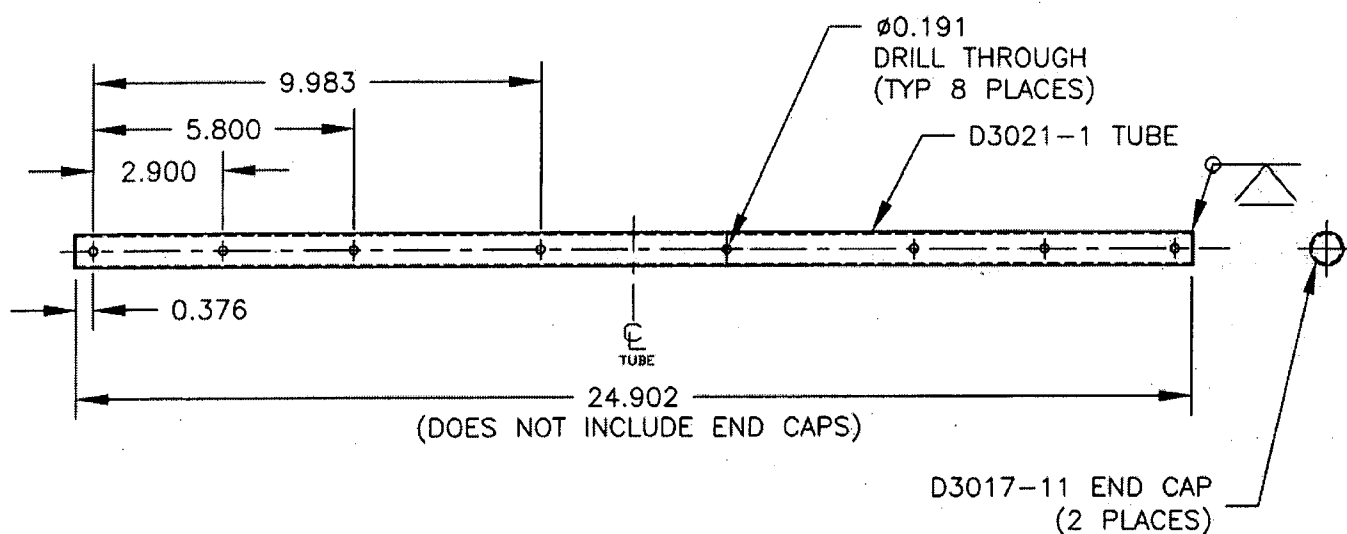
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3021	REV. A SHEET 1 OF 1
DATE 01.05.18		TITLE TUBE ASSEMBLY	SCALE 1:4
A	01.05.18	NEW ISSUE	



D3021-041 TUBE ASSEMBLY
(D3021-1 TUBE)

NOTES:

- 1) PART IS SYMMETRIC ABOUT CENTERLINE
- 2) MATERIAL: AISI 4130 TUBE, $\phi 0.75$ DIA x 0.049 WALL (M4130N-T0750W049)
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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WORK ORDER

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01.05.30 9

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